

THE POSTAGE STAMP

HOW IT IS MADE BY UNCLE SAM'S
EXPERT WORKMEN.The Manufacturing Process From
the Engraving of the Steel Die to
the Finished Gummed, Pressed and
Perforated Printed Sheet.

The first mechanical process in the manufacture of a postage stamp is the cutting, or engraving, of the die. This is a piece of steel of the finest quality, on the polished surface of which a man slowly and patiently cuts, line by line, the portrait or other emblem which has been adopted for this particular stamp. A steel engraving is what is called an incised plate—that is, every line which is to show in the finished print is cut into the surface instead of being left in relief, as in wood engraving.

The die which the engraver cuts is a "negative," in other words, a reversal of the design which the stamp will show. The reason for this soon becomes apparent.

When the die is finished and proofs show it to be satisfactory it is hardened and fixed in the bed of a powerful press. Over it is then passed a steel roller, the circumference of which is several times, perhaps four times, the diameter of the die. Immense pressure is applied, so that every line on the surface of the die is impressed upon the surface of the roller as many times as the circumference of the roller is larger than the area of the die. In this way four perfect copies of the die are reproduced on the roller, but reversed. Each of these impressions is a "positive."

This roller is now hardened in turn in order that it may transmit the impressions once more, this time to the plate from which the actual printing is to be made. This plate is also of steel. The size is sufficient to print a whole sheet of stamps—from 200 to 300—at a single impression.

Into the surface of this plate the impression on the roller is forced by great pressure, once for each stamp in the subsequent sheet, and then the plate is hardened. These impressions are negatives, so that the prints from them—the stamps themselves—will be positives.

The reason for all this preliminary work is most interesting. In the first place, printing could not be done from a single die because of the vast quantities of stamps required. In the second place, it could not be done from the roller, because on that the lines are in relief instead of being incised, and in the third place, it would not be feasible to have several dies or a large number of them engraved, both because the expense would be prohibitive and because no two would then be absolutely alike. The present system makes it certain that every stamp of a certain lot is exactly like every other of the same lot—a great safeguard against counterfeiting.

When three printing plates have been made they are all fastened to the bed of a special printing press. When the machinery is started the first plate is inked, then automatically wiped until it is like a mirror. The wiping removes all the ink except what clings in the lines of the 200 duplicate engravings which dot the surface.

Over the plate is laid a sheet of dampened paper, the plate is slightly warmed in order to permit the ink to swell, and heavy pressure is applied. Meanwhile the second plate is receiving its ink, and then the third comes into play, so that, although all three are on the same press, each is at a given moment undergoing a different process from either of the other two. This has wrought a great saving of time over the old process of printing by hand. When the printed sheets are dry they go to the gumming machine, in which they pass between a dry roller on one side and one moistened with mucilage on the other. From these rollers they are cast out, wet side up, upon an endless web, which carries them through a steam heated box.

They come out dry, ready for the perforations, which permit them to be torn apart easily. These are very easily made by passing the sheets between one cylinder studded with steel pins and another perforated with holes to match the pins. The two together act like the jaws of a conductor's punch.

The last process is pressing the sheets by hydraulic power to counteract the tendency to curl, which is imparted by the mucilage.

The printing of stamps, like the printing of gold and silver certificates and bank notes, is subject to the most careful and constant inspection.

Every sheet of paper is counted before it is delivered to the printer, and when he goes home at night he must turn exactly the same number of sheets, either of perfect stamps or of waste paper, and no "seconds" or "thirds" are given away to visitors.—and William Frenz in Youth's Companion.

The Elephant's Eye.
They said two things strike the eye vividly when standing close to elephants in their native

haunts," writes a traveler. "The one is the gigantic size and his own comparative smallness. The other is the expression of the eye. This organ, which is surprisingly small in proportion to the size of the animal and set far back in the head, is of a pale blue color much resembling that of a wall eye in a horse. Even when an elephant is at rest his eye has an uncomfortably cold and sinister look."

A Hero by Accident.

"There's no telling what moment a man's fortune may turn or what may decide the turning," remarked the visitor, who had been listening to the interchange of stories.

"That's so," agreed one of the bystanders. "The only question is whether the man's got the wit to see the chance and the grit to make use of it."

"Well, even that isn't always necessary. I was out on the frontier some years back when a young fellow I knew to be a 'white head' was promoted in his regiment and paraded in all the eastern papers for his courage and coolness. He had been sent out to meet an attacking party of Indians. He didn't want to go at all. He actually trembled when he confessed to me it was his first call to dangerous duty and he'd give anything on earth to be out of the affair. In less than twenty-four hours the station was ringing with the way he had held his ground, even when his men had bent a retreat. It was a miracle he wasn't captured or killed, staying there single handed to face and fire on the advancing foe."

"Just one of those instances of a man finding his native courage in the presence of real danger?"

"Not a bit of it. He was riding a mule, and just at the critical moment the animal planted his feet and refused to budge."—Youth's Companion.

Cured of Bright's Disease.

Geo. A. Sherman, Lisbon Red Mills, Lawrence county, N. Y., writes: "I had kidney disease for many years and had been treated by physicians for twelve years; had taken a well known kidney medicine and other remedies that were recommended but got no relief until I began using Foley's Kidney Cure. The first half bottle relieved me and four bottles have cured me of this terrible disease. Before I began taking Foley's Kidney Cure I had to make water about every fifteen minutes, day and night, and passed a brick-dust substance, and sometimes a slimy substance. I believe I would have died if I had not taken Foley's Kidney Cure." J. W. McCollum & Co.

Long Winded Oratory.

It is no new thing for the house of commons to suffer from long winded oratory. As long ago as the sixteenth century Queen Bess soundly rated her lawmakers for not working more and talking less, and some years later Speaker Long actually succumbed to a succession of lengthy speeches. "The house is empty, and so be our stomachs," one impatient member declared. "I pray you, therefore, adjourn the debate for an hour." But the speaker declined to budge from the post of duty, with the result that he was taken ill and died shortly after. Brougham once spoke for six hours on end on law reform, Sheridan and Gladstone both have records of five hour speeches, Mr. Bigger tied their record, and Palmerston once held forth for four hours and a half on Don Pacifico.

Cuban Diarrhoea.

U. S. soldiers who served in Cuba during the Spanish war know what this disease is, and that ordinary remedies have little more effect than so much water. Cuban diarrhoea is almost as severe and dangerous as a mild attack of cholera. There is one remedy, however, that can always be depended upon, as will be seen by the following certificate from Mrs. Minnie Jacobs of Houston, Texas: "I hereby certify that Chamberlain's Colic, Cholera and Diarrhoea Remedy cured my husband of a severe attack of Cuban diarrhoea, which he brought home from Cuba. We had several doctors but they did him no good. One bottle of this remedy cured him, as our neighbors will testify. I thank God for so valuable a medicine." For sale by all druggists.

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Lv A M	Lv P M	Lv A M		Ar P M	Ar P M	Ar P M
7 45	2 15		Fairfield	1 30		8 10
7 55	2 35		Irvine	1 07		8 00
8 00	2 45		Dungarvan	1 00		8 55
8 05	2 55		Southside	12 55		8 50
8 10	3 00		Hickman	12 50		8 45
8 15	3 10		Lake Blumont	12 45		8 40
8 30	3 30		Micanopy	12 30		8 30
8 35	3 40		Tacoma	12 20		8 20
8 45	3 45		Kirkwood	12 15		8 15
8 50	3 55		Clyatt	12 10		8 10
9 03	4 15		Wachoota	12 00		8 05
9 15	4 40		Rocky Point	11 45		8 00
9 45 Ar	5 00		Gainesville	12 30		8 10
11 00 Lv	6 15 Lv	6 30		9 20	10 10 Ar	8 30
11 55	6 40	6 55	Bellamy	8 55		8 20
12 00	6 55	7 05	Cyrt	8 40		8 10
12 20	7 08	7 12	Graham	8 32		8 00
12 40	7 15 Ar	7 28	Sampson City	8 20		7 50
	9 50	10 50	Palatka, G. S. & F.	8 50		7 40
			Lake City, G. S. & F.	7 04		7 42
			Tallahassee, S. A. L.	1 48		
			Valdosta, G. S. & F.	4 50		8 20
			Macon, G. S. & F.	11 39		12 40
			Atlanta, C. of Ga.	7 50		9 00
Ar P M	Ar A M	Ar P M		Lv A M	Lv P M	

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2:00 p m Daily	Palatka, Jacksonville, North, East and West	1:55 p m Daily
12:05 p m Daily	High Springs, Waycross, Savannah, Brunswick, Albany, Atlanta, all Points North, East West	8:15 p m Daily
8:15 p m Daily	Rochelle, Micanopy and Citra	9:55 a m Daily
8:50 a m Daily ex. Monday	High Springs	7:20 p m Daily ex. Sunday

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Lv Jessup So. Ry 11 54a 10 40p	Lv Jessup, Ga. So. Ry. 10 30p	Lv Jessup, Ga. So. Ry. 10 30p
Lv Savannah So. Ry 1 30p 12 15a	Ar Mason, Ga. So. Ry. 8 00a	Ar Mason, Ga. So. Ry. 8 00a
Ar Columbia So. Ry 6 55p 6 00a	Ar Atlanta, Ga. So. Ry. 5 20a	Ar Atlanta, Ga. So. Ry. 5 20a
Ar Charlotte So. Ry 10 05p 9 55a	Ar Rome, Ga. So. Ry. 7 30a	Ar Rome, Ga. So. Ry. 7 30a
Ar Greensboro So. Ry 12 55a 12 51p	Ar Dalton, Ga. So. Ry. 5 25a	Ar Dalton, Ga. So. Ry. 5 25a
Ar Danville So. Ry 2 05a 2 10p	Ar Chattanooga, Tenn. So. Ry. 9 45a	Ar Chattanooga, Tenn. So. Ry. 9 45a
Ar Richmond So. Ry 6 55a 6 42p	Ar Lexington, Ky. Q. & O. 8 30p	Ar Lexington, Ky. Q. & O. 8 30p
Ar Lynchburg So. Ry 4 17a 4 30p	Ar Cincinnati, O. Q. & O. 7 40p	Ar Cincinnati, O. Q. & O. 7 40p
Ar Charlottesville So. Ry 6 02a 6 10p	Lv Cincinnati, O. Big Four 8 40p	Lv Cincinnati, O. Big Four 8 40p
Ar Washington So. Ry 9 45a 9 50p	Ar Chicago, Ill. Pa Lines 7 10a	Ar Chicago, Ill. Pa Lines 7 10a
Ar Baltimore P. R. R. 11 30a 11 25p	Lv Cincinnati, O. Pa Lines 8 30p	Lv Cincinnati, O. Pa Lines 8 30p
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